



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18526-PO
Job Sheet 199276



Part No: RBT18526-PO

Job Qty: 2 pcs

Part Name: Main Rotor Blade Bolt Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/16/19

Job Tracking No:

Created By: Kimberley Guerin

Due Date: 9/13/19

Description:

Note: DWG RBT18526 Rev. C IPP Rev. A 18.07.06 new issue DP Verify DD/IPP Rev. B 19.08.14 drawing revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing <i>Armateck</i>	2 pcs		9/13/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs		9/13/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S213739



Part: RBT18526

Job No: 199276

Serial No/Batch: S213739

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 09/13/19

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	9/13/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	61
				QC 6 - 40	9-89
				QC 6 - 81	
150 Packaging 3-1 - Stock - B4B	2 pcs	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - FG	2 pcs	9/13/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	AUG 26 2019 DAS
				QC 21 - SA - 53	SEP 16 2019 70
Part Op 100 - Purchasing - Issue PO to ARROW TECH MACHINE WORKS P/O: _____ MANUFACTURE RBT18526 AS Descriptions: PER DWG -Certificate of conformity is required 110 - Receive & Inspect for Damage & Mat'l Certs 120 - QC6- All purchased or subcontracted products 150 - Identify as per dwg & Stock Location: _____ The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG. 160 - QC21- Final Inspection - Work Order Release					

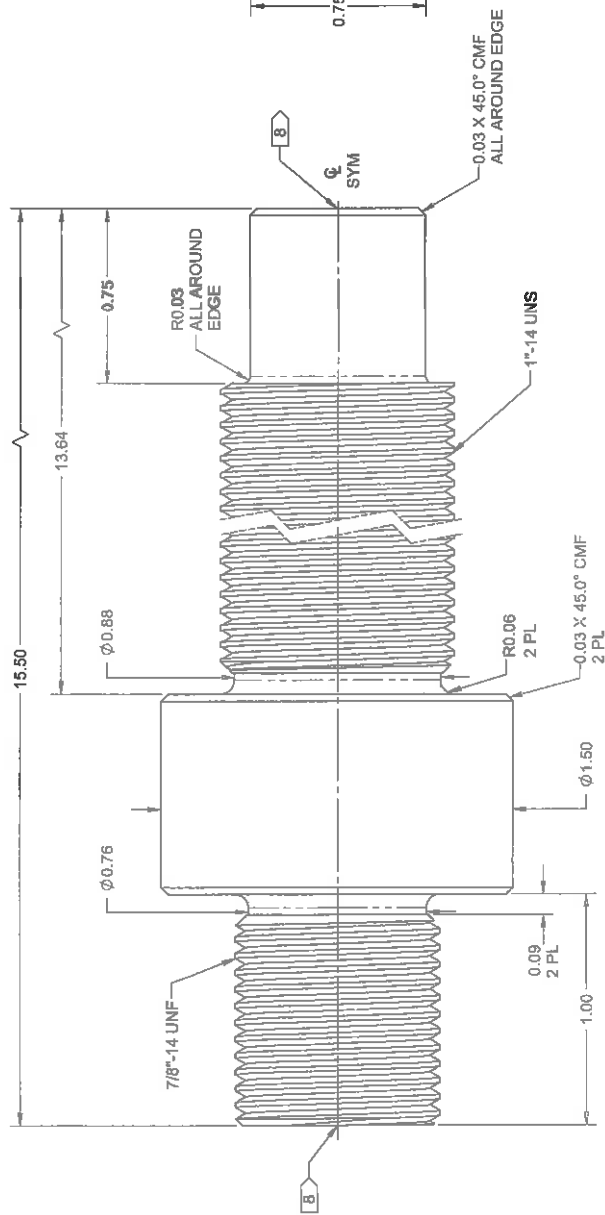
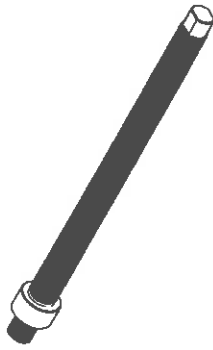
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBT18526P	Main Rotor Blade Bolt Extractor	2 Ea (1 ea)	100-Purchasing	SZ13738

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT18526P	2	0	0

Part Specifications				
Specifications could not be found.				

Plex 8/16/19 9:29 AM Dart.Guerin.Kimberley

1 2 3 4 5 6 7 8

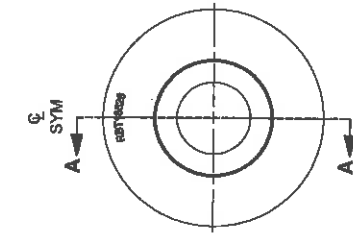
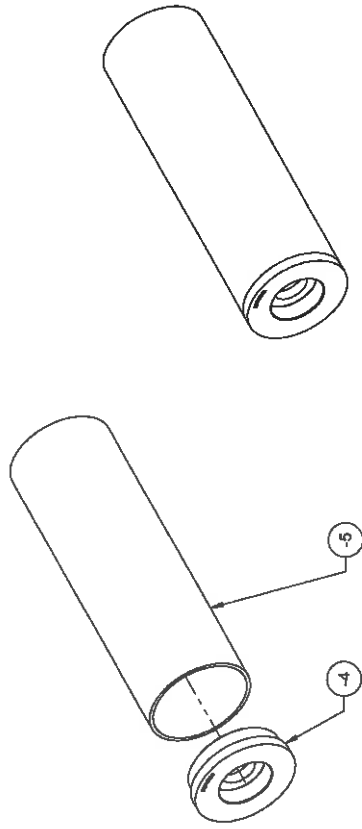


RBT18526-1 THREADED PULLER ROD

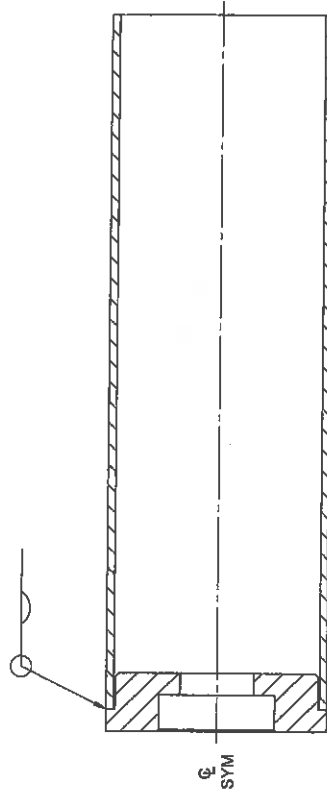
NOTES:
1) MATERIAL: 4140 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13024 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III
OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: XX = +/- 0.1" / +/- 1"
XXX = +/- 0.01" / +/- 0.5"
XXXX = +/- 0.005" / +/- 0.1"
XXXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	VM	VM	REV C
DRAWN	VM	VM	VM	SHEET 2 OF 5
CHECKED	WPT	WPT	WPT	SCALE
MFG. APPR.	WPT	WPT	WPT	NTS
APPROVED	WPT	WPT	WPT	
DATE	2019-08-14			
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
TOOL PART # RBT18526				
TITLE M/R BLADE BOLT EXTRACTOR NTS				
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NOT FOR REPRODUCTION OR DISTRIBUTION WITHOUT PERMISSION				

ITEM #	QTY	PART #	PART TITLE
-4	1	RBT18526-4	BEARING PLATE
-5	1	RBT18526-5	TUBE



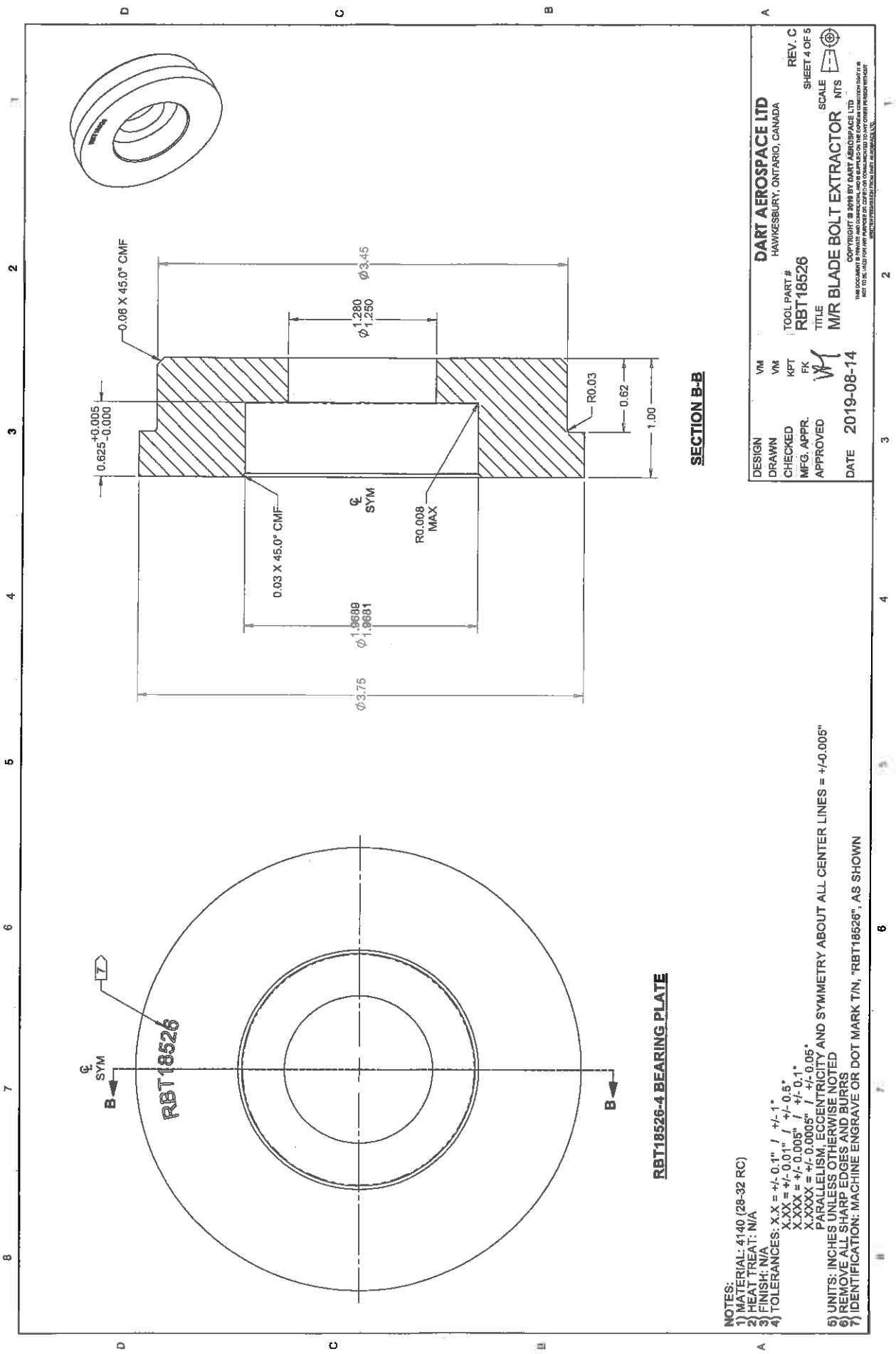
SECTION A-A

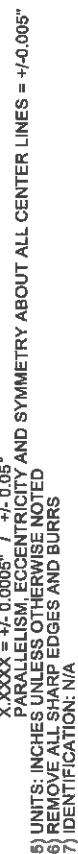


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

DESIGN	VM	VM	DART AEROSPACE LTD
DRAWN	VM	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	VM	FX	TOOL PART #
MFG. APPR.	VM	FX	RBT18526
APPROVED	VM	FX	TITLE
DATE	2019-08-14		M/R BLADE BOLT EXTRACTOR NTS

REV C
SHEET 3 OF 5
SCALE
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044283



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044283

PO Date: 8/16/19

Due Date: 9/16/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-08-16

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199276	RBT18526P			Main Rotor Blade Bolt Extractor, as per dwg RevC	Firmed -		9/16/19	2 Ea	0 Ea	2 Ea	\$915.85/Ea	\$1,831.70
						XZ		SEP 13 2019			DAS 61 9-89		DP

Grand Total: \$1,831.70

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 8/16/19 3:54 PM Dart.Guerin.Kimberley



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 699

Date: 9/12/2019
PO Ref: HB044283
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty
2

Item
MAIN ROTOR BLADE BOLT EXTRACTOR

Part No.
RBT18526 REV-C

DAS
61
9-89

RECEIVED

SEP 13 2019

DART AEROSPACE LTD.

Received by:

Packaged by: *JM.2*

Checked by: *ALL*

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044283

Dated: 9/12/2019

Our Order / Job No: AWT-HB044283

Order Qty: 2

Part Name: M/R BLADE BOLT EXTRACTOR

Part Number RBT18526

Lot Size: N/A

Ship Date: 9/12/2019



We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBT18526

Rev: C

Material Size and Type: -1, -4/4140 STEEL Q&T; -5/A153 DOM STEEL

Material Specifications: 1018 STEEL: ASTM A108, ASTM A29; DOM STEEL: ASTM A513

Heat Treatment: (28-32 RC)

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D; YELLOW ZINC: ASTM B633 TYPE 2 CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 09/12/19

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com